Date

Thursday, 5/4/2006 10:46:30 AM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 26975

Estimate Number

: 10534

P.O. Number This Issue

: NA

: 5/4/2006

S.O. No. : NA

Prsht Rev. First Issue

: NC : NIA

: MACHINED PARTS

: 26563 Previous Run

Written By Checked & Approved By

Comment

: Est Rev: I

As Per RevE

Drawing Name

: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Part Number

: D2574

: D2574 REV E

Drawing Number

Project Number **Drawing Revision**

: N/A : E

Material

Due Date

:NIA : 5/25/2006

12 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101005

7075-T7351 8.25X5.0X2.5

Comment: Qty.:

1.0000 Each(s)/Unit

Total:

12.0000 Each(s)

7075-T7351 8,25X5,0X2,5

Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length

Batch No: 1323946

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1





Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 24975Double check by: J.L

> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

3.0

MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574



4.0

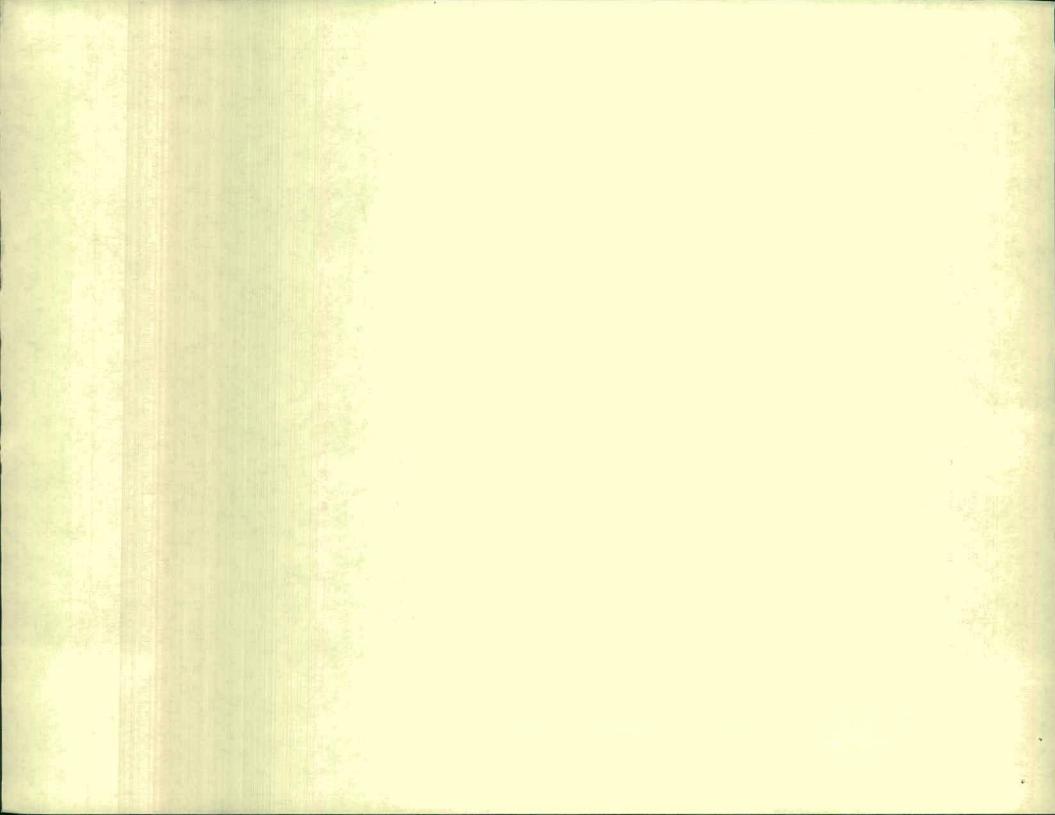
QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





Thursday, 5/4/2006 10:46:30 AM Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 26975

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK



6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-06-13

80

7.0

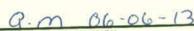
POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 45

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

A velor

Job Completion



U 06.06.14



DART AEROSPACE LTD	Work Order:	26975
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

		Recorded Actual Dimensions							
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682		0-440	0 440			
B-	1.745	1.755		1.748	1.748	1.749	1.746.		
C	3.495	3.505		3.498	3 ~ 498	3.50	3498		
D	1.745	1.755		1.748	8.003	1.749	1.746		
E	7.990	8.010		7.998	8,003	6.000	8003		
F	0.490	0.510		0.499	0.400	0.501	0495		
G	0.257	0.262	DT8683		0.358	0-358			
H	0.375	0.380	DT8684		0.376	6.376	<u>ا</u>		
I	0.490	0.510		0 501	0.498	0-499	0.498		
J	1.174	1.184		1.186	1.180	1.180	1.174		
K	0.558	0.578		0.567	0.500	0.568	0563		
L	1.174	1.184		1.180	1-179	1.373 2.499	4174		
M	1.365	1.375		1.376	1.371	1.372	1.367		
N	2.495	2.505		2.499	9.418	2.499	2 495		
0	4.119	4.129		4.123	4.121	161.1	4.123		
Р	0.115	0.135		0.121	0.123	0.124	0.126		
Q	0.115	0.135		0.135	0.133	0.134	0-135		
R	0.240	0.260	-11.553	0.248	0.247	0.134	942 0-25	-1	
S	0.115	0.135		0.123	0.122	0-121	0.126		
T	0.178	0.198		0:188	0.188	6.188	0-188		
U	3.210	3.250		3.230	0.188	6.188 3.236 0.337	2730		
V	0.230	0.250		R 277	0.238	0.237	0.738		
W	0.115	0.135		6.127	0.130	0.130	e-132		
X	0.307	0.312		0.3/2	0.309	0.310	6.316		
Y	0.760	0.765		1.760	0.761	0.761	0.763		
Z	0.352	0.372		0.372		0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	e0.5 ∞		
AB	0.615	0.635		0.626	0-624	0,693	0.620		
AC	0.053	0.073		0.0003	0-063	0.063	0-063		
AD	0.240	0.260		0.245	0.246	0.245	6248		
AE	1.500	1.520		1 512	1 513	1 =14	1:505		
AF	0.115	0.135		0.135	0.134	0.132	6.135		
AG	0.240	0.280		0.273	0 - 270	0-971	0-2790		
AH	0.240	0.260		0.245	0.341	0.340	045		
Al	2.000	2.020			LUNGT		4 BURED		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
	Acc	ept/Reje	ct						

Measured by: 5.6	Audited by	
Date: 06/05/85	Date: 06/6/13	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.27	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	-1
E	05.12.05	Added dimension AJ	KJ/JLM ox	Gul
				777

